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(54) **LIQUID EJECTION HEAD AND METHOD OF MANUFACTURING THE SAME**

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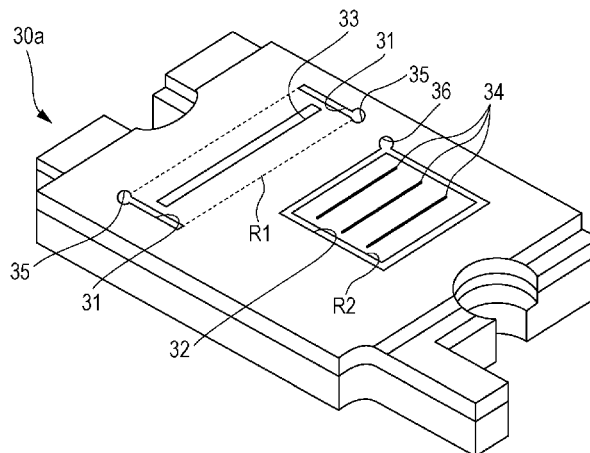
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(57) **ABSTRACT**

A liquid ejection head includes a recording element substrate that ejects liquid, and an element-substrate support member to which the recording element substrate is bonded with an adhesive. A groove to be filled with the adhesive is provided in a bonding region of the element-substrate support member, at which the element-substrate support member and the recording element substrate are bonded together, along a part or an entirety of the outer circumference of the recording element substrate.

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13 Claims, 7 Drawing Sheets



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FIG. 1A

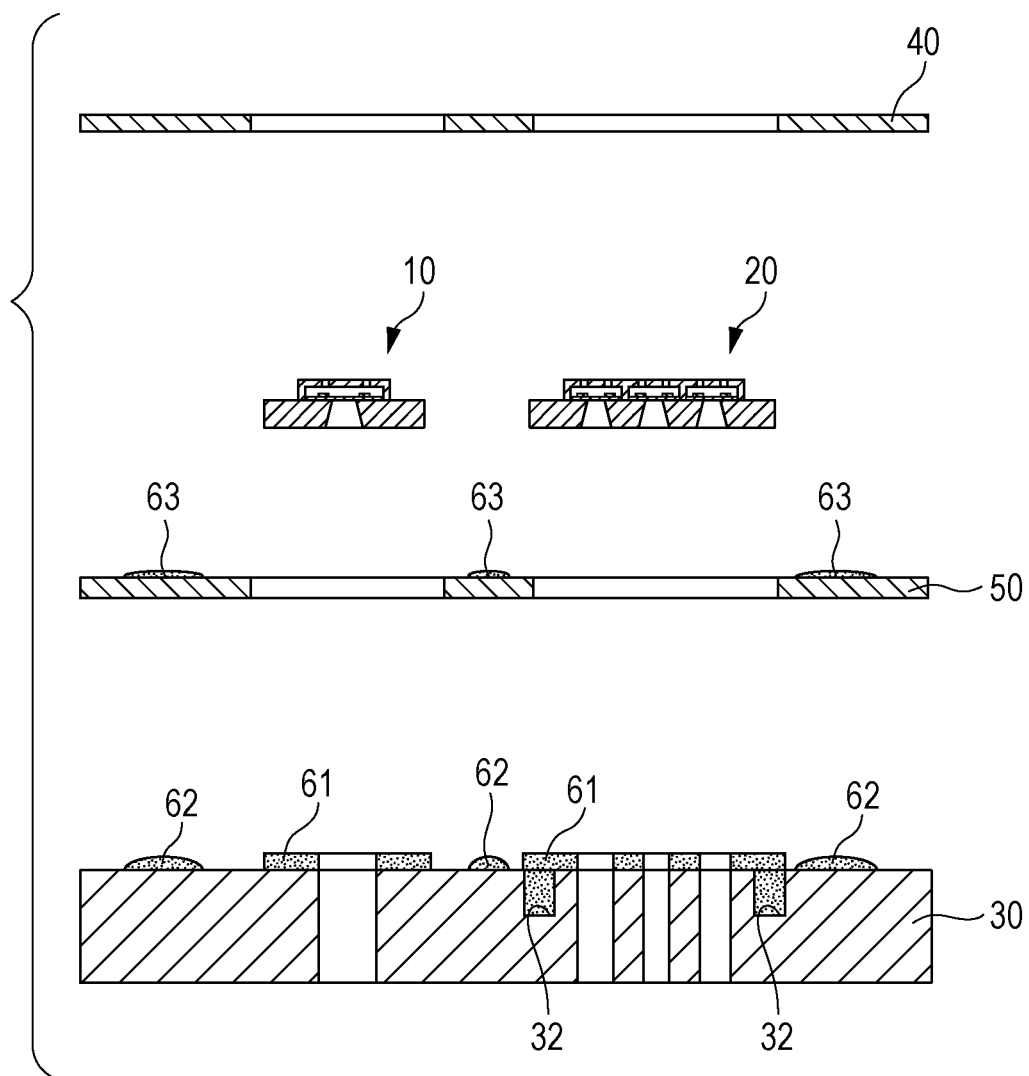


FIG. 1B

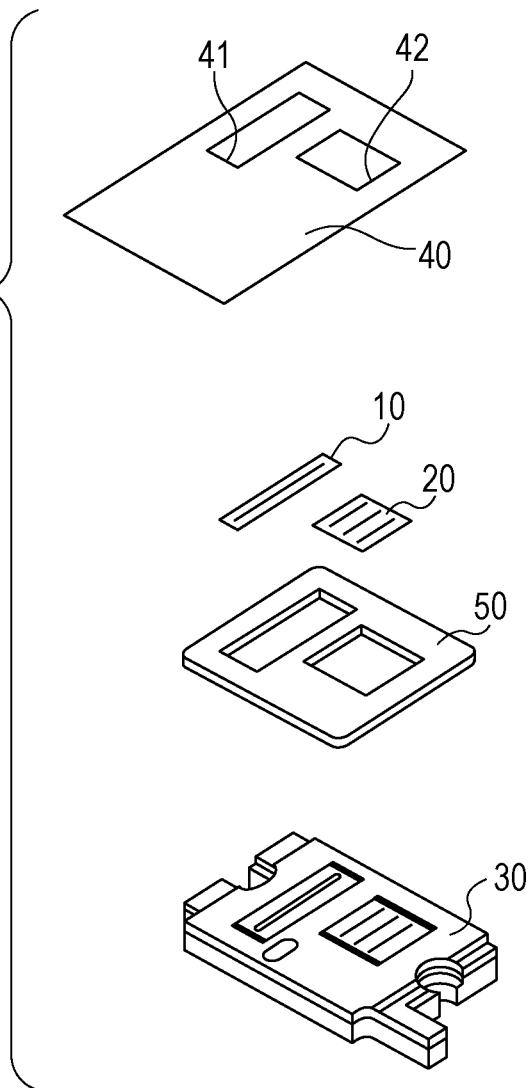


FIG. 2A

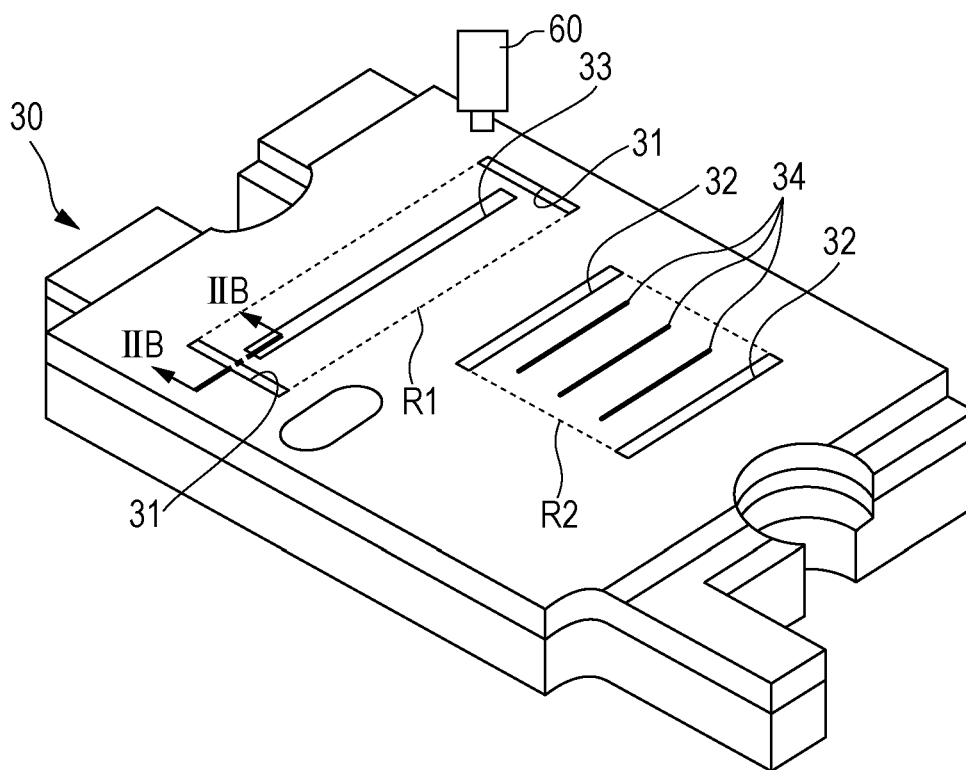


FIG. 2B

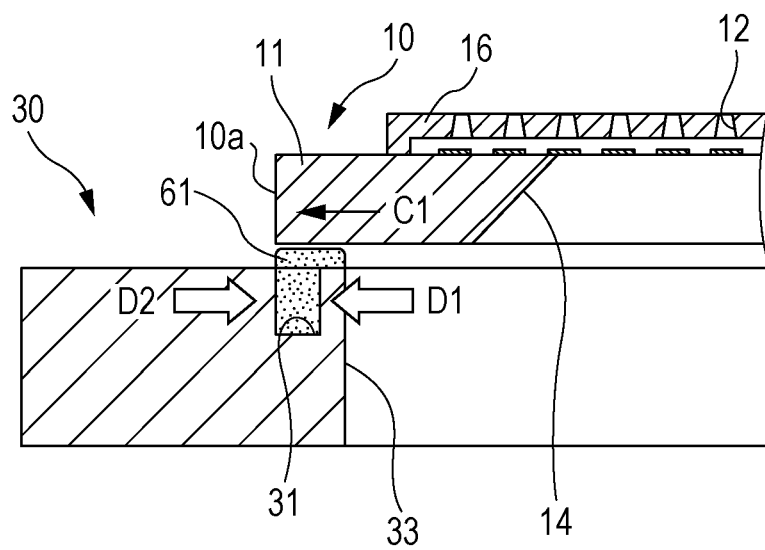


FIG. 3A

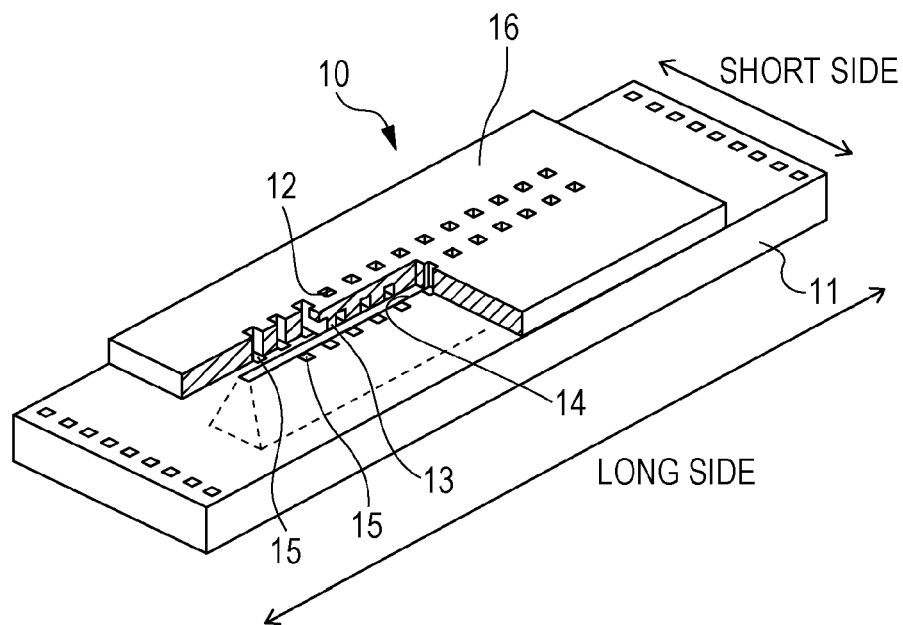
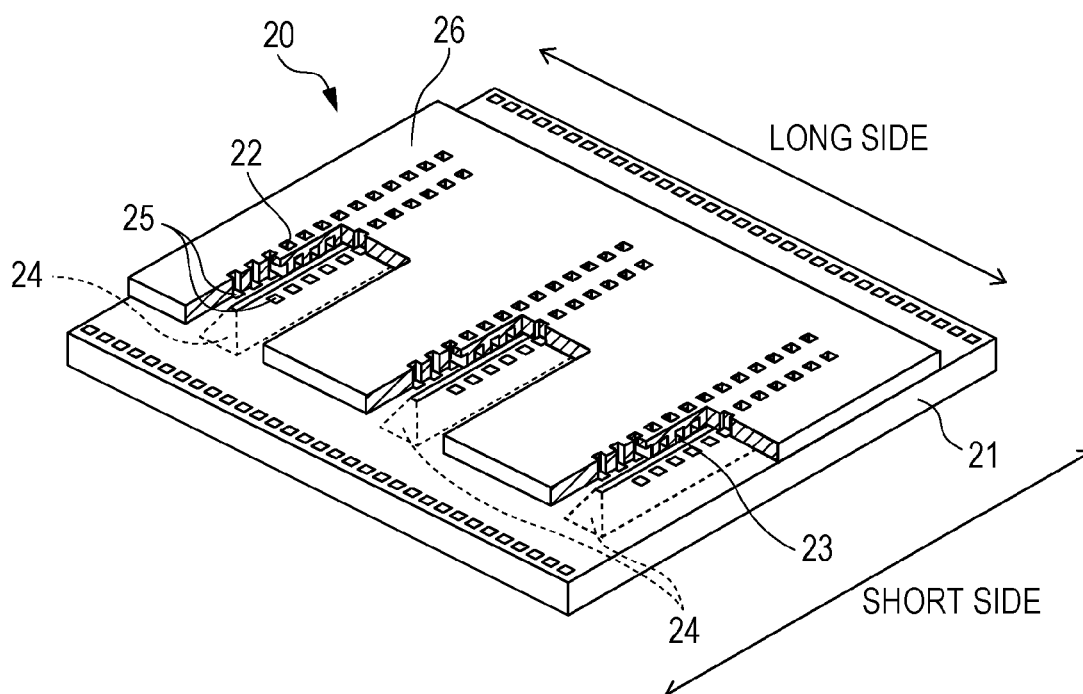


FIG. 3B



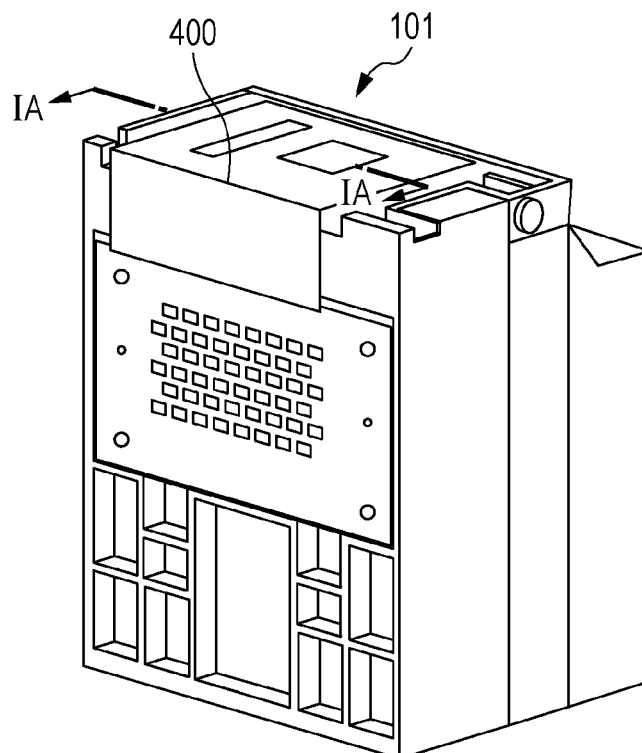


FIG. 6A

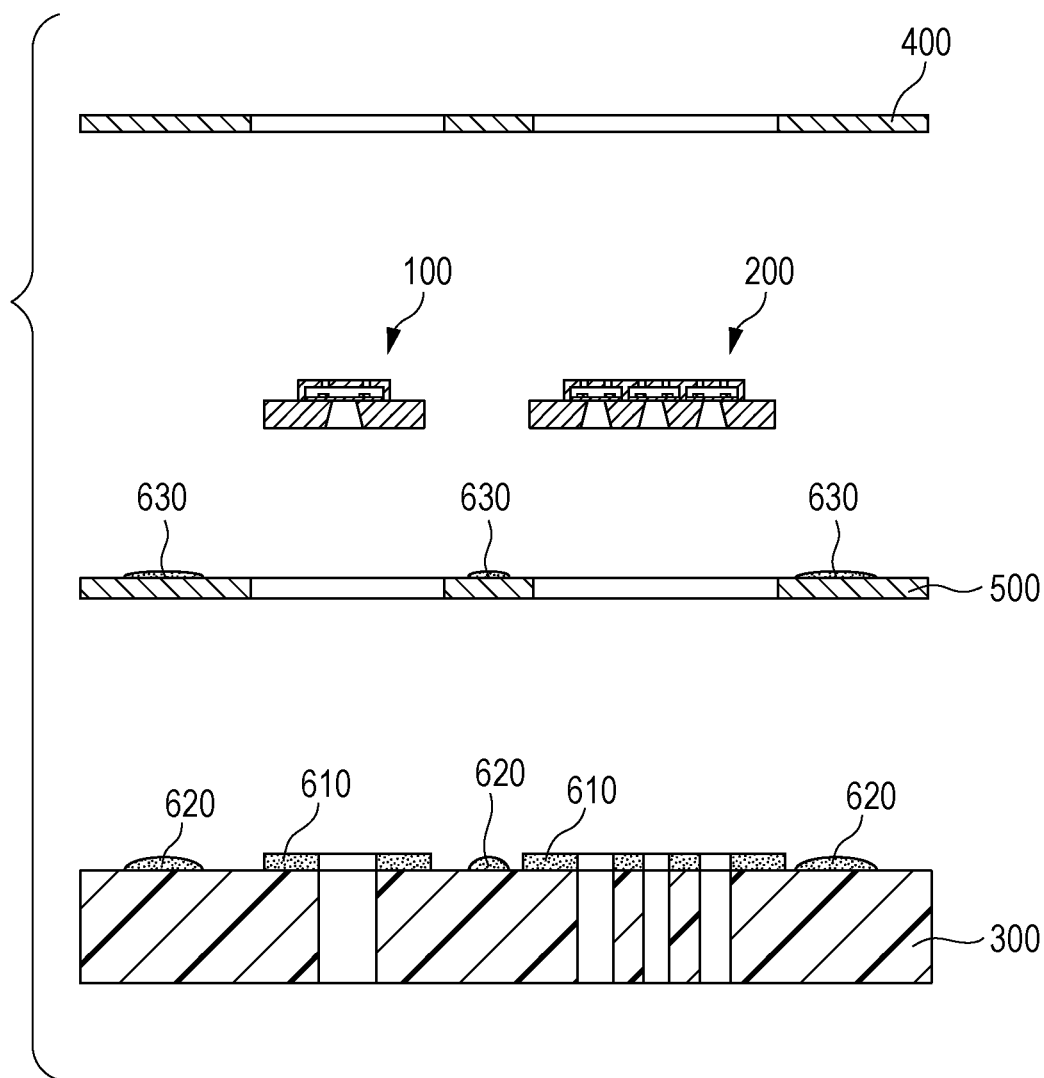
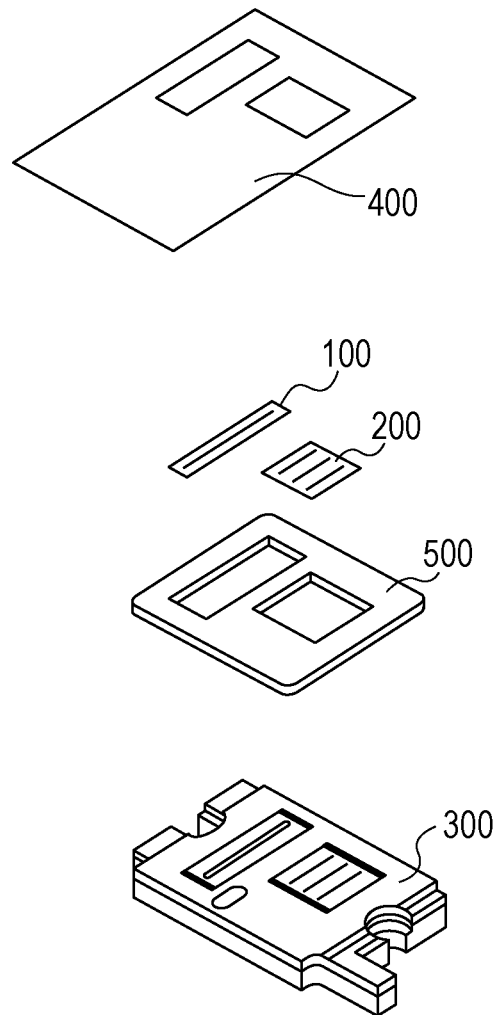


FIG. 6B



LIQUID EJECTION HEAD AND METHOD OF MANUFACTURING THE SAME

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a liquid ejection head that ejects liquid and to a method of manufacturing the liquid ejection head.

2. Description of the Related Art

Liquid ejection recording apparatuses perform recording by ejecting liquid onto recording media, such as paper, and have the following characteristics: high-speed recording, ability to record on various recording media, little mechanical noise during recording, low running cost, etc. FIG. 6A is an exploded sectional view showing components of a conventional liquid ejection head. FIG. 6B is a perspective view of the components shown in FIG. 6A. The conventional liquid ejection head includes recording element substrates **100** and **200**, an element-substrate support member **300**, a wiring substrate **400**, and a wiring-substrate support member **500**. The recording element substrates **100** and **200** are bonded to a flat surface of the element-substrate support member **300** with an adhesive **610**. The recording element substrates **100** and **200** are electrically connected to the wiring substrate **400**. The wiring substrate **400** is bonded to the wiring-substrate support member **500** with an adhesive **630**. The wiring-substrate support member **500** is bonded to the element-substrate support member **300** with an adhesive **620**.

In Japanese Unexamined Patent Application Publication No. 2002-19119, a thermosetting adhesive is used as the above-described adhesives. When the thermosetting adhesive is cured by heating in an oven, the recording element substrates **100** and **200** and the wiring-substrate support member **500** are bonded to the element-substrate support member **300**, and the wiring substrate **400** is bonded to the wiring-substrate support member **500**.

Furthermore, Japanese Unexamined Patent Application Publication No. 2007-55071 discloses that a light-curable adhesive is used to bond the recording element substrate and the element-substrate support member. In the technique disclosed in Japanese Unexamined Patent Application Publication No. 2007-55071, the light-curable adhesive is applied to four corners of a bonding surface of the recording element substrate and is irradiated with light (ultraviolet). Thus, the recording element substrate is bonded to the element-substrate support member.

In the conventional liquid ejection head as shown in FIG. 6, typically, the recording element substrates are made of silicon, and the element-substrate support member is made of resin. Thus, the coefficient of linear expansion of the recording element substrates is smaller than that of the element-substrate support member. Hence, if heat treatment is performed to bond the recording element substrates and the element-substrate support member with the thermosetting adhesive, as in Japanese Unexamined Patent Application Publication No. 2002-19119, a tensile stress due to the difference in coefficient of linear expansion therebetween is generated in the recording element substrates. Furthermore, after the heat treatment, a compressive stress due to cooling of the recording element substrates and the element-substrate support member is generated in the recording element substrates. As a result, deformation and displacement of the recording element substrates due to these stresses may occur. In contrast, if the recording element substrates and the element-substrate support member are bonded together with a light-curable adhesive, as disclosed in Japanese Unexamined

Patent Application Publication No. 2007-55071, an increase in temperature of the recording element substrates and the element-substrate support member can be suppressed compared with the case where a thermosetting adhesive is used, and hence, deformation and displacement of the recording element substrates are reduced. However, further reductions in deformation and displacement of the recording element substrates are required, as will be described below.

In recent years, liquid ejection recording apparatuses are required to perform recording at higher speeds. High-speed recording may be achieved by two-way printing, in which a liquid ejection head ejects liquid both while moving from one end to the other end and while moving from the other end to one end as it reciprocates. However, two-way printing requires higher liquid-landing precision than one-way printing. In one-way printing, because there is one printing direction, displacement of the liquid-landing position may be corrected to some extent by printing correction. However, in two-way printing, if displacement of the liquid-landing position occurs in each of the two directions, correction of such displacement is relatively difficult. Thus, further reductions in deformation and displacement of the recording element substrates are required. Because temperature rise occurs also when a light-curable adhesive is applied to the flat surface of the element-substrate support member and the recording element substrates are bonded thereto, deformation and displacement of the recording element substrates due to the stress caused by thermal expansion remain.

SUMMARY OF THE INVENTION

According to an aspect of the present invention, a liquid ejection head includes a recording element substrate that ejects liquid and an element-substrate support member to which the recording element substrate is bonded with an adhesive. A groove to be filled with the adhesive is provided in a bonding region of the element-substrate support member, at which the element-substrate support member and the recording element substrate are bonded together, along a part or an entirety of the outer circumference of the recording element substrate.

Further features of the present invention will become apparent from the following description of exemplary embodiments with reference to the attached drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIGS. 1A and 1B are a sectional view and a perspective view showing the configuration of a liquid ejection head according to a first embodiment, respectively.

FIGS. 2A and 2B are a perspective view and a sectional view of an element-substrate support member shown in FIG. 1, respectively.

FIGS. 3A and 3B are perspective views of a recording element substrate shown in FIG. 1.

FIG. 4 is a perspective view of an element-substrate support member according to a second embodiment.

FIG. 5 is a perspective view of a liquid ejection head according to the embodiments of the present invention.

FIGS. 6A and 6B are an exploded sectional view and an exploded perspective view showing the conventional liquid ejection head, respectively.

DESCRIPTION OF THE EMBODIMENTS

First Embodiment

A first embodiment of the present invention will be described below. FIG. 5 is a perspective view of a liquid

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ejection head **101**, which ejects liquid, such as ink, according to embodiments of the present invention. FIG. 1A is an exploded sectional view taken along line IA-IA in FIG. 5, showing the respective components. FIG. 1B is a perspective view of the respective components of the liquid ejection head shown in FIG. 1A.

As shown in FIGS. 1A and 1B, a liquid ejection head **1** according to this embodiment includes a recording element substrate **10** (a first recording element substrate), a recording element substrate **20** (a second recording element substrate), an element-substrate support member (a support member) **30**, a wiring substrate **40**, and a wiring-substrate support member **50**. The recording element substrates **10** and **20** are bonded to the element-substrate support member **30** with an adhesive **61**. Furthermore, the recording element substrates **10** and **20** are electrically connected to the wiring substrate **40**, which is formed of a flexible film or the like and has a plurality of wires, and eject liquid by receiving supply of power from the wiring substrate **40**. The wiring substrate **40** is bonded to the wiring-substrate support member **50** with an adhesive **63**. The wiring-substrate support member **50** is bonded to the element-substrate support member **30** with an adhesive **62**.

FIG. 2A is a perspective view of the element-substrate support member **30**. FIG. 2B is a partial sectional view taken along line IIB-IIB in FIG. 2A. FIG. 2B shows a state in which the recording element substrate **10** is bonded to the element-substrate support member **30**, for ease of explanation.

A bonding region **R1** shown in FIG. 2A is a region where the element-substrate support member **30** and the recording element substrate **10** are in contact with and bonded to each other with the adhesive **61**. Furthermore, a bonding region **R2** is a region where the element-substrate support member **30** and the recording element substrate **20** are in contact with and bonded to each other with the adhesive **61**. In this embodiment, the recording element substrates **10** and **20** are substantially rectangular.

Furthermore, in this embodiment, grooves **31** and **32** are provided in the surface of the element-substrate support member **30**, to which the recording element substrates **10** and **20** are to be bonded. More specifically, in the surface of the element-substrate support member **30**, the grooves **31** are provided at positions along the short sides, in the outer circumference, of the recording element substrate **10**, and the grooves **32** are provided at positions along the short sides, in the outer circumference, of the recording element substrate **20**.

An opening (through-hole) **33** is provided within the bonding region **R1** in the surface of the element-substrate support member **30**, and black (first color) liquid (in this embodiment, ink) is supplied to the recording element substrate **10** through the opening **33**. Similarly, three openings **34** are provided within the bonding region **R2**, and three colored liquids (in this embodiment, color inks) other than black are individually supplied to the recording element substrate **20** through the openings **34**.

FIG. 3A is a perspective view of the recording element substrate **10**, and FIG. 3B is a perspective view of the recording element substrate **20**. FIGS. 3A and 3B are schematic perspective views for explaining the inside configuration, in which members **16** and **26** are partially cut away to expose the inside structures of the recording element substrates **10** and **20**. The recording element substrate **10** for black ink includes a substrate **11** that has energy generating elements **15** for generating energy to eject liquid, and a member **16** that has ejection ports **12** through which the liquid is ejected. A flow path **13** is formed at a bonding portion between the substrate

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11 and the member **16**. The recording element substrate **20** for color inks has the same configuration.

As shown in FIG. 3A, in the recording element substrate **10**, a supply port **14**, which is a rectangular opening, is provided at the center of the silicon substrate **11**. The supply port **14** communicates with an opening **33** in the element-substrate support member **30** (see FIG. 2B). The energy generating elements **15** for generating energy to eject liquid are arranged on both sides of the supply port **14**, at substantially equal intervals. The ejection ports **12**, through which the liquid is ejected, are provided at positions facing the energy generating elements **15**. The flow path **13** is formed between the energy generating elements **15** and the ejection ports **12**.

As shown in FIG. 3B, in the second recording element substrate **20**, three supply ports **24**, which are rectangular openings, are provided in parallel in the silicon substrate **21**. Each of the supply ports **24** communicates with the corresponding one of the openings **34** in the element-substrate support member **30**. A plurality of energy generating elements **25** are arranged on both sides of each supply port **24**, at substantially equal intervals. A plurality of ejection ports **22**, through which the liquid is ejected, are provided at positions facing the energy generating elements **25**. Flow paths **23** are formed between the energy generating elements **25** and the ejection ports **22**.

In the recording element substrates **10** and **20**, liquid flowing in the supply ports **14** and **24** reach the energy generating elements **15** and **25**. When the energy generating elements **15** and **25** heat the liquid, bubbles are formed by film boiling. These bubbles cause the liquid to be ejected from the ejection ports **12** and **22**. The wiring substrate **40** is provided with wires (not shown) etc. for supplying power to the energy generating elements **15** and **25**. The wiring substrate **40** is also provided with openings **41** and **42** from which the recording element substrates **10** and **20** are exposed, respectively (see FIG. 1B). Although the liquid ejection head according to this embodiment uses heat-generating elements as the energy generating elements **15** and **25**, various other energy generating elements, such as piezoelectric transducers, etc., may also be used in the present invention.

A method of manufacturing the liquid ejection head **1** according to this embodiment will be described below.

First, the element-substrate support member **30** is formed by powder press forming. In this embodiment, the element-substrate support member **30** is made of alumina (aluminum oxide), whose coefficient of linear expansion is relatively close to that of the material of the recording element substrates **10** and **20** (in this embodiment, silicon). The grooves **31** and **32** are formed by this powder press forming. The wiring-substrate support member **50** is also made of alumina by powder press forming, similarly to the element-substrate support member **30**.

Next, the adhesive **62** is applied to the bonding region of the element-substrate support member **30** relative to the wiring-substrate support member **50**, and the wiring-substrate support member **50** is disposed on the adhesive **62**. Then, the adhesive **61** is applied to the bonding regions **R1** and **R2**. At this time, the adhesive **61** is applied so as to fill the grooves **31** and **32**. In this embodiment, a filling step in which the adhesive **61** is applied to the bonding regions **R1** and **R2** and in which the adhesive **61** is injected into the grooves **31** and **32** is performed by using a dispenser **60** (see FIG. 2A) that discharges the adhesive **61** by means of compressed air.

After the adhesive **61** is injected into the grooves **31** and **32**, the recording element substrates **10** and **20** are disposed onto the bonding regions **R1** and **R2**, respectively, and heat treatment is performed in an oven. Then, the adhesive **63** is applied

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to the wiring-substrate support member **50**, and the wiring substrate **40** is bonded thereto. Finally, the recording element substrates **10** and **20** are electrically connected to the wiring substrate **40** by inner-lead bonding, and the electrically connected portions are sealed with a sealing material. Thus, the liquid ejection head **101** is formed.

The above-described recording element substrates **10** and **20** of the recording head **101** according to this embodiment were observed, and the levels of deformation thereof before and after being bonded to the element-substrate support member **30** were measured. As a result, it was confirmed that the deformation was smaller than that in the case where the grooves **31** were not provided. Furthermore, as a result of examining the liquid-landing precision by performing printing, it was confirmed that the liquid-landing precision was higher than that in the case where the grooves **31** were not provided. From these results, it was confirmed that the stress that causes deformation and displacement of the recording element substrates **10** and **20** when the recording element substrates **10** and **20** are bonded to the element-substrate support member **30** with the adhesive **61** was reduced. The reason for this will be described below with reference to FIG. 2B.

When the heat treatment is performed to cure the adhesive **61**, stress **C1** due to thermal expansion is generated in a short side **10a** of the recording element substrate **10**, as shown in FIG. 2B. Similarly, stress **D1** due to thermal expansion is generated in the element-substrate support member **30**.

As in this embodiment, by providing the grooves **31** and **32** in the element-substrate support member **30**, at positions corresponding to the ends of the recording element substrates **10** and **20**, expansion of the element-substrate support member **30** due to the heat treatment is suppressed. This is because the grooves **31** and **32** inhibit propagation of the stress. In this embodiment, the grooves **31** and **32** are filled with the adhesive. The adhesive in the grooves **31** and **32** expands by the heat treatment. As shown in FIG. 2B, the thickness of a right wall of the groove **31** is smaller than that of a left wall of the groove **31**. Hence, when the adhesive expands, the right wall (i.e., a member between the groove **31** and the opening **33**) of the groove **31** is deformed by a greater amount than the left wall. Because a force acting in a direction opposite to the direction of the stress **D1** is generated, expansion of the element-substrate support member **30** is reduced.

Furthermore, in this embodiment, the coefficient of linear expansion and volume of the element-substrate support member **30**, which is made of alumina, are greater than those of the substrate **11**, which is made of silicon. Hence, the stress **D1** is greater than the stress **C1**. In the element-substrate support member **30**, a stress **D2**, which is a reaction force to the thermal expansion of the adhesive **61** injected into the groove **31**, is generated. As shown in FIG. 2B, the stress **D2** acts in a direction opposite to the direction of the stress **D1**.

In the conventional liquid ejection head (see FIG. 6), in which the grooves **31** are not provided and the recording element substrates are bonded to the flat surface of the element-substrate support member, the difference between the stress **D1** and the stress **C1** is large. Hence, a relatively large tensile stress is applied to the recording element substrate **10**. As a result, deformation and displacement of the recording element substrate **10** may occur. However, in the liquid ejection head **1** according to this embodiment, as described above, the stress **D2** that acts in the direction opposite to the direction of the stress **D1** is generated. Thus, the stress generated in the element-substrate support member **30** equals **D1-D2**. Because the difference in stress between the recording element substrate **10** and the element-substrate support

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member **30** is reduced by **-D2**, the tensile stress applied to the recording element substrate **10** is reduced. In short, the adhesive **61** injected into the grooves **31** contributes to reductions in deformation and displacement of the recording element substrate **10**. Reductions in deformation and displacement of the recording element substrate **20** are achieved by the same mechanism. As a result, the liquid-landing precision is improved, enabling high-speed recording by two-way printing. In this embodiment, the grooves **31** are provided at positions corresponding to the short sides of the outer circumferences of the recording element substrates **10** and **20**. Because the influence of the above-described stresses is greater at the short sides than at the long sides in rectangular recording element substrates, the provision of the grooves **31** at positions corresponding to, at least, the short sides is effective. Although the provision of the grooves over the entire width of the short sides, as shown in FIG. 2A, is effective, the present invention may be applied to a configuration in which the groove is provided at, at least, part of the short sides or in which a plurality of grooves are provided in a non-continuous manner. Furthermore, the grooves **31** may be partially provided outside the bonding regions **R1** and **R2**, as long as the grooves **31** are provided at positions corresponding to regions between the supply ports **14** and **24** and the short sides of the recording element substrates **10** and **20**.

Although the adhesive **61** is a thermosetting adhesive in this embodiment, it may be a light-curable adhesive. When the adhesive **61** is a light-curable adhesive, the adhesive **61** is cured by light-radiation treatment, in which an ultraviolet ray is radiated, instead of the heat treatment. Because temperature rises of the recording element substrates **10** and **20** and element-substrate support member **30** can be suppressed by using the light-curable adhesive, compared with a case where the thermosetting adhesive is used, deformation and displacement of the recording element substrates **10** and **20** can be further reduced.

Second Embodiment

A second embodiment of the present invention will be described below focusing on the differences from the first embodiment. FIG. 4 is a perspective view of an element-substrate support member provided on a liquid ejection head according to this embodiment. The same components as those of the element-substrate support member **30** according to the first embodiment will be denoted by the same reference numerals, and detailed descriptions thereof will be omitted.

An element-substrate support member **30a** shown in FIG. 4 is made of resin and is formed integrally with the wiring-substrate support member **50** by injection molding. Note that FIG. 4 does not show the wiring-substrate support member **50**. In the element-substrate support member **30a**, the grooves **31** are provided along the short sides of the recording element substrate **10**, as those according to the first embodiment. On the other hand, the groove **32** is provided along the entire outer circumference of the recording element substrate **20**. The recording element substrate **10** has a rectangular shape in which the difference in length between the long sides and the short sides is greater than that of the recording element substrate **20**. In the recording element substrates having such a shape, the stress generated by increasing the temperature to cure the adhesive is greater at the short sides than at the long sides. Thus, the grooves **31** are provided only along the short sides of the recording element substrate **10**. Note that the groove **31** may be provided along the entire outer circumference of the recording element substrate **10**. On the other hand, the recording element substrate **20** has a rectangular shape in

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which the difference in length between the long sides and the short sides is smaller than that of the recording element substrate **10**. In the recording element substrates having such a shape, the same stress is applied to the long sides and the short sides. Thus, in this embodiment, the groove **32** is provided along the entire outer circumference of the recording element substrate **20**. When a plurality of recording element substrates having different planar aspect ratios are provided in one liquid ejection head, it is desirable that grooves be provided only along the short sides of a recording element substrate that has a relatively large aspect ratio and that grooves be provided along both the short sides and the long sides of a recording element substrate that has a relatively small aspect ratio. By doing so, the size of the liquid ejection heads, as well as the manufacturing cycle time thereof, can be reduced.

Furthermore, the element-substrate support member **30a** according to this embodiment is provided with recesses **35** and **36**. The recesses **35** are provided outside the bonding region **R1** and communicate with the grooves **31**. On the other hand, the recess **36** is provided outside the bonding region **R2** and communicates with the groove **32**. The function of the recesses **35** and **36** will be described below.

In this embodiment too, similarly to the first embodiment, the adhesive **61** is applied to the bonding regions **R1** and **R2** and is injected into the grooves **31** and **32** by using the dispenser **60**. Because the dispenser **60** uses compressed air to discharge the adhesive **61**, bubbles may be formed in the adhesive **61**. In particular, it is highly probable that a first portion of the adhesive **61** discharged from the dispenser **60** contain bubbles. If the recording element substrates **10** and **20** are bonded to the element-substrate support member **30** with the adhesive **61** containing bubbles, bonding may be insufficient.

To overcome this problem, in this embodiment, first, a tip of the dispenser **60** is inserted into the recesses **35** and **36**, and the adhesive **61** containing bubbles is discharged therein. Then, the dispenser **60** is moved, and the adhesive **61** is injected into the grooves **31** and **32**. By doing so, it is possible to fill the grooves **31** and **32** with the adhesive **61** that contains a reduced amount of bubbles. Note that, it is desirable that the depth and width of the recesses **35** and **36** be larger than those of the grooves **31** and **32** to ensure sufficient capacity for receiving the adhesive **61** containing bubbles. This configuration can prevent the adhesive **61** containing bubbles from flowing into the grooves **31** and **32**.

In this embodiment, the dispenser **60** departs from the recess **36**, moves along the groove **32**, and returns to the recess **36**, while discharging the adhesive. Then, the dispenser **60** moves to the recess **35** adjacent to the recess **36** and restarts the discharge of the adhesive at the recess **35**. When the recesses **36** and **35** are adjacent to each other as in this case, the dispenser **60** can be moved along the shortest route, reducing the time needed to apply the adhesive. Because the element-substrate support member **30a** according to this embodiment is made of resin, the coefficient of linear expansion thereof is larger than that of the element-substrate support member **30** according to the first embodiment, which is made of alumina. Because the difference in coefficient of linear expansion between resin and silicon is much larger than that between alumina and silicon, the configuration of the present invention is more effective in this embodiment.

Comparison Example

A comparison example to be compared with the first and second embodiments of the present invention will be described below. A liquid ejection head according to this

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comparison example is a liquid ejection head **101** shown in FIG. **6**. An element-substrate support member **300** of the liquid ejection head **101** is made of resin and does not have the grooves **31** or **32**. In this liquid ejection head **101**, after the adhesive **610** was applied, the recording element substrates **100** and **200** were disposed on the adhesive **610** and heated in an oven. As a result of observation of the recording element substrates **100** and **200**, under which the adhesive **610** was cured by heat, a cracked recording element substrate was found. Furthermore, as a result of performing inner-lead bonding on a recording element substrate that was crack-free, deformation of the inner lead was found. The deformation of the inner lead may be caused by failure to bond the inner lead to the proper position due to displacement of the recording element substrate. Hence, as in the present invention, by injecting the adhesive into the grooves provided in the element-substrate support member, the stresses applied to the recording element substrates are reduced, improving reductions in deformation and displacement of the recording element substrates.

In the present invention, because concentration of stress on one side portion of the recording element substrates can be avoided by providing a sealing member and a deformation preventing member, displacement of the recording element substrates can be suppressed. As a result, lowering of the liquid-landing precision of the liquid ejected from the liquid ejection head of the present invention is suppressed. Accordingly, an ink jet printer that employs the liquid ejection head of the present invention can perform high-quality recording.

While the present invention has been described with reference to exemplary embodiments, it is to be understood that the invention is not limited to the disclosed exemplary embodiments. The scope of the following claims is to be accorded the broadest interpretation so as to encompass all such modifications and equivalent structures and functions.

This application claims the benefit of Japanese Patent Application No. 2014-098368, filed May 12, 2014 and Japanese Patent Application No. 2015-056092, filed Mar. 19, 2015, which are hereby incorporated by reference herein in their entirety.

What is claimed is:

1. A liquid ejection head comprising:

a recording element substrate that ejects liquid; and
an element-substrate support member to which the recording element substrate is bonded with an adhesive,
wherein a groove to be filled with the adhesive is provided in a bonding region of the element-substrate support member, at which the element-substrate support member and the recording element substrate are bonded together, along a part or an entirety of an outer circumference of the recording element substrate,
wherein the recording element substrate includes a first recording element substrate and a second recording element substrate that has a planar aspect ratio smaller than a planar aspect ratio of the first recording element substrate,
wherein the groove is provided in a bonding region of the element-substrate support member, at which the element-substrate support member and the first recording element substrate are bonded together, along a short side of the outer circumference of the first recording element substrate, and no groove is provided along a long side of the outer circumference of the first recording element substrate, and

wherein the groove is provided in a bonding region of the element-substrate support member, at which the element-substrate support member and the second recording

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- ing element substrate are bonded together, along each of a short side and a long side of the outer circumference of the second recording element substrate.
2. The liquid ejection head according to claim 1, wherein the recording element substrate is rectangular, and wherein the groove is provided along a short side of the recording element substrate.
 3. The liquid ejection head according to claim 1, wherein a recess that communicates with the groove is provided outside the bonding region of the element-substrate support member.
 4. The liquid ejection head according to claim 3, wherein the depth of the recess is larger than the depth of the groove.
 5. The liquid ejection head according to claim 3, wherein the width of the recess is larger than the width of the groove.
 6. The liquid ejection head according to claim 1, wherein the recording element substrate includes a first recording element substrate that ejects a liquid of a first color and a second recording element substrate that ejects a liquid of a second color different than the first color, and wherein the groove is provided along each of the outer circumferences of the first and second recording element substrates.
 7. The liquid ejection head according to claim 1, wherein the adhesive is a light-curable adhesive.
 8. The liquid ejection head according to claim 1, wherein the adhesive is a thermosetting adhesive.
 9. The liquid ejection head according to claim 1, wherein the element-substrate support member is made of resin.

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10. The liquid ejection head according to claim 1, wherein the element-substrate support member is provided with a through-hole through which the liquid is supplied to the recording element substrate, and wherein a distance between the groove and the through-hole is smaller than a distance between the groove and an end of the element-substrate support member that is closest to the groove.
11. A method of manufacturing a liquid ejection head including a recording element substrate that ejects liquid, and an element-substrate support member to which the recording element substrate is bonded with an adhesive, the method comprising:
 - forming a groove in a bonding region of the element-substrate support member, at which the element-substrate support member and the recording element substrate are bonded together, along a part or an entirety of an outer circumference of the recording element substrate; and
 - filling by applying the adhesive to the bonding region and injecting the adhesive into the groove, wherein the groove forming step includes forming a recess that communicates with the groove, and wherein the filling step includes discharging, with a dispenser, the adhesive into the recess before injecting the adhesive into the groove.
12. The method of manufacturing a liquid ejection head according to claim 11, wherein the filling step is performed by using a dispenser that discharges adhesive by means of compressed air.
13. The method of manufacturing a liquid ejection head according to claim 11, wherein the adhesive is a light-curable adhesive.

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